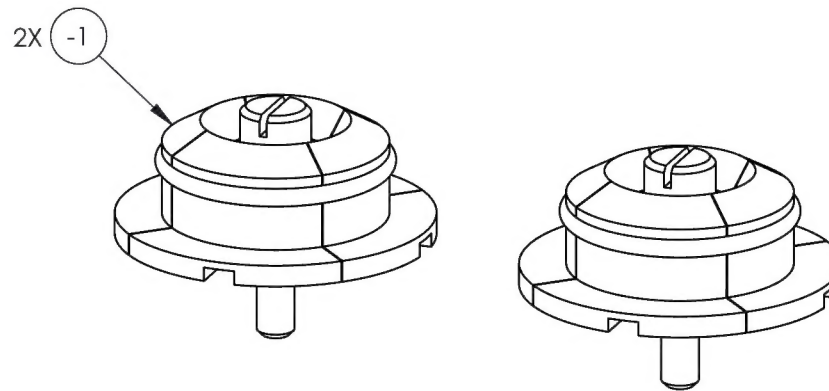


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	12/9/2016	DPD	JAG



NOTES:

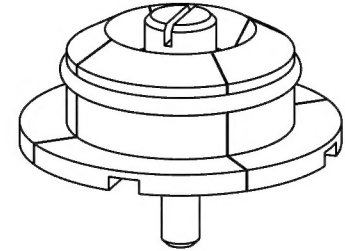
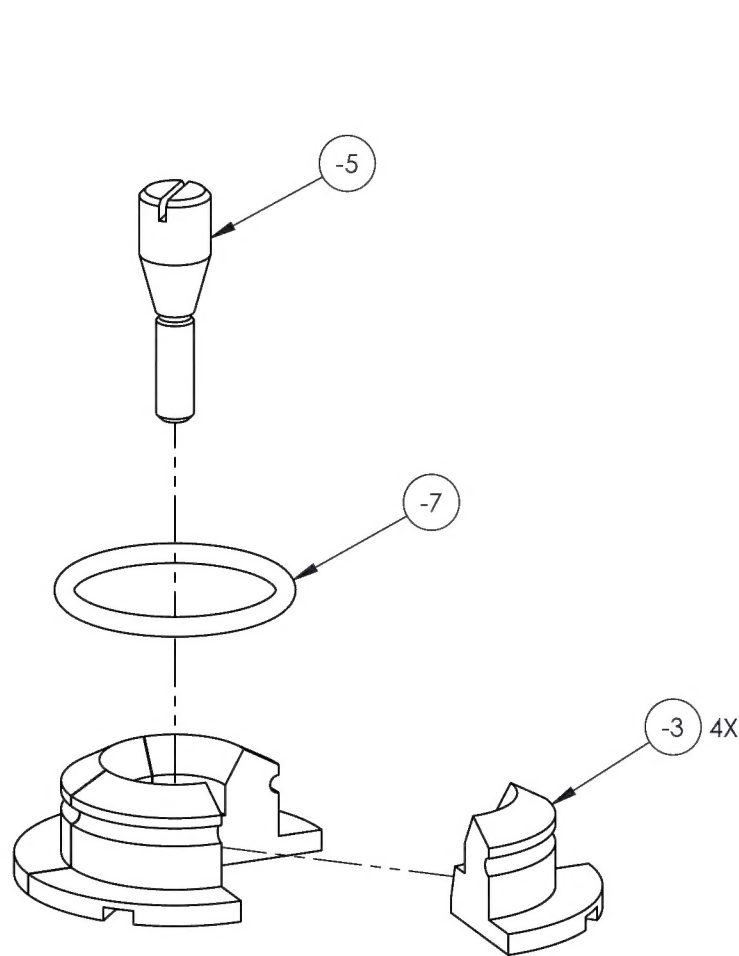
1. REF. AIRBUS T/N: 105-45361W3.
2. USE WITH RBE105-40001W1.
3. REPLACEMENT FOR:
105-45361W2
105-31781W3

DART AEROSPACE																	
TITLE STAKING TOOL																	
DWG NO. RBE105-45361W3	REV 1																
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>SPEC</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES = 125°</td> </tr> <tr> <td></td> <td>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td></td> <td>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td></td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT TREAT	DIMENSIONS ARE IN INCHES	FINISH	.XXX ± .005 FRACTIONS ± 1/8	SPEC	.XX ± .01 ANGLES ± 5°		.X ± .1 SURFACES = 125°		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		2. DIMENSIONAL LIMITS APPLY AFTER PLATING		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
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<table border="1"> <tr> <td>DRAWN BY:</td> <td>DUERFELDT</td> </tr> <tr> <td>CHECKED:</td> <td>CLOUGH</td> </tr> <tr> <td>OPPS APPR:</td> <td>ANDERSON</td> </tr> <tr> <td>QA APPR:</td> <td>LINDSAY</td> </tr> <tr> <td>APPROVED:</td> <td>GILBERT</td> </tr> </table>		DRAWN BY:	DUERFELDT	CHECKED:	CLOUGH	OPPS APPR:	ANDERSON	QA APPR:	LINDSAY	APPROVED:	GILBERT						
DRAWN BY:	DUERFELDT																
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QA APPR:	LINDSAY																
APPROVED:	GILBERT																
<table border="1"> <tr> <td>SCALE</td> <td>1:1</td> </tr> <tr> <td>DATE</td> <td>8/31/2016</td> </tr> <tr> <td colspan="2">SHEET 1 OF 4</td> </tr> </table>		SCALE	1:1	DATE	8/31/2016	SHEET 1 OF 4											
SCALE	1:1																
DATE	8/31/2016																
SHEET 1 OF 4																	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	2	STAKING TOOL ASSEMBLY			2
	4		-3		STAKING INSERT	O1		3
	1		-5		POSITIONING SCREW	O1		4
	1	B/O	-7		O-RING	BUNA-N	Ø3/32 C.S. X Ø1-1/16 I.D. (MCMMASTER-CARR #9452K85)	2
	ASSY -1							

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED

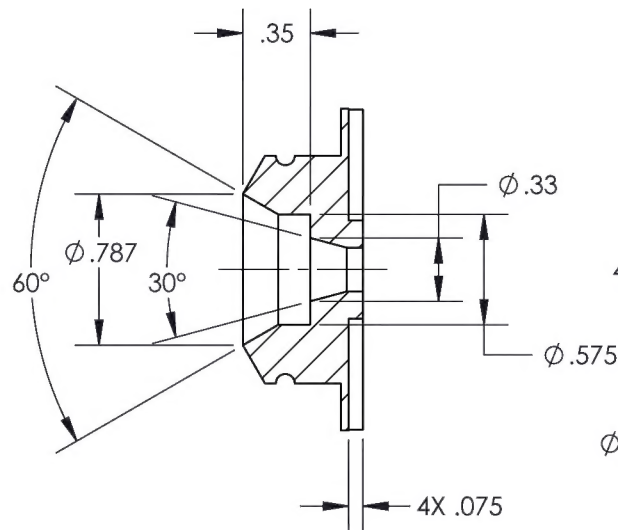
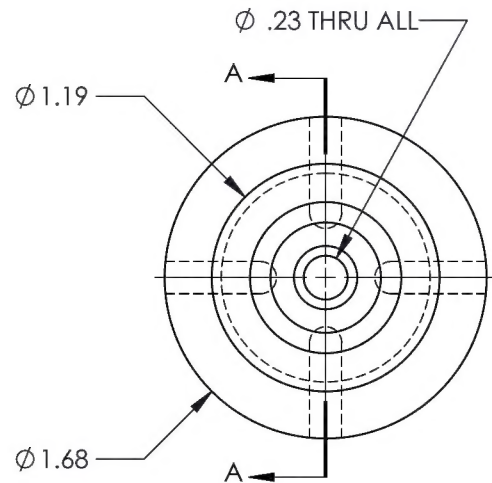


(-1)
STAKING TOOL ASSEMBLY

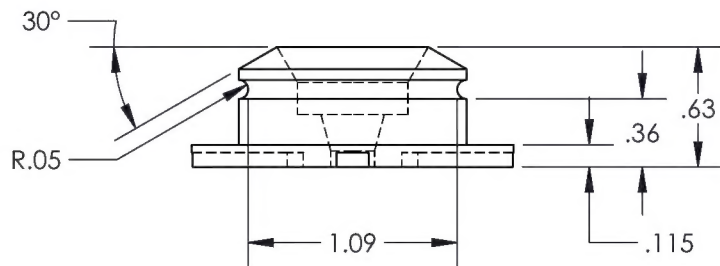
DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-45361W3-1	REV 1
MAT'L REAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145, EC645
SCALE 1:1	DATE 8/31/2016
SHEET 2 OF 4	

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REVISIONS				
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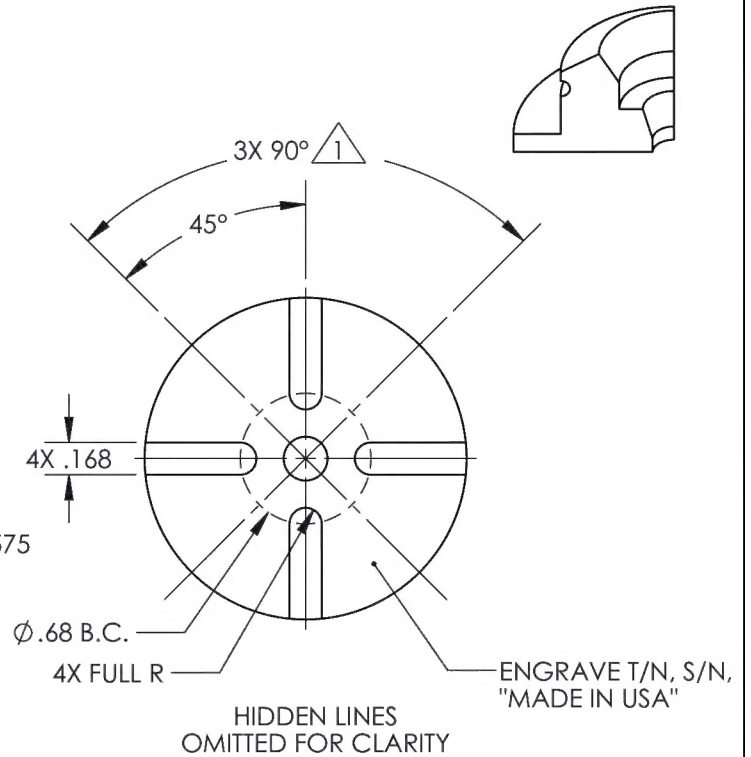


SECTION A-A



(-3)

STAKING INSERT



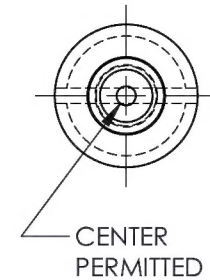
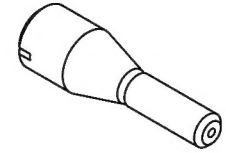
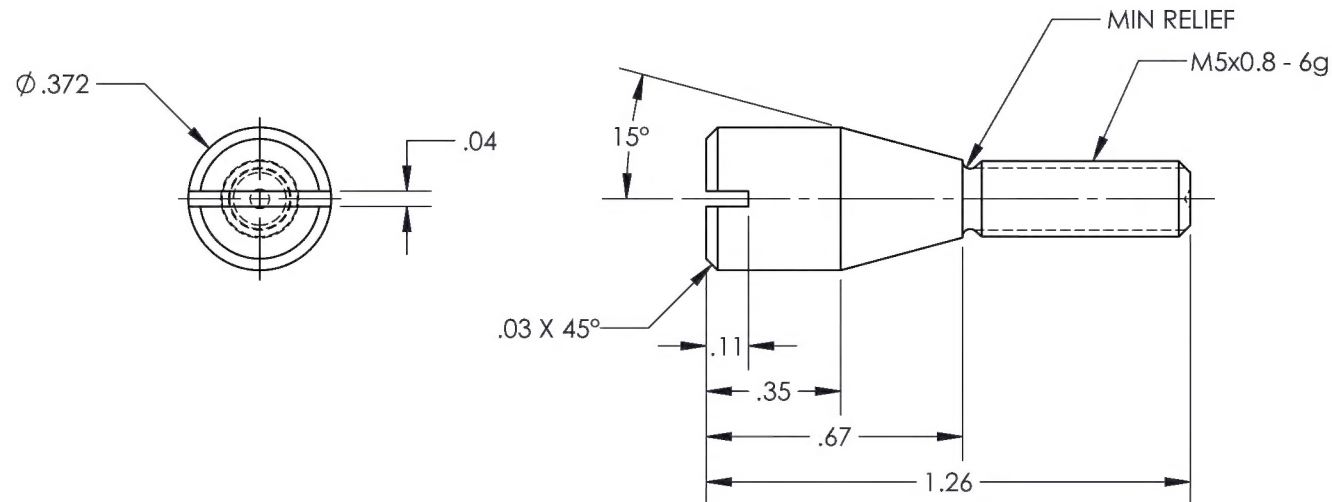
NOTE:

1 EDM TO SPLIT INTO 4 EQUAL PIECES.

DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-45361W3-3	REV 1
MAT'L O1 HEAT TREAT RC 50-60 FINISH ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125✓
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145, EC645
SCALE 1:1	DATE 8/31/2016
	SHEET 3 OF 4

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(-5)
POSITIONING SCREW

DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-45361W3-5	REV 1
MAT'L O1 RC 50-60 ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145, EC645
SCALE 2:1	DATE 8/31/2016 SHEET 4 OF 4